

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002053**Date Inspected:** 13-Dec-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sha Zhi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Mock-Ups**Summary of Items Observed:**

The Caltrans Quality Assurance Inspector (QA), M. Paul Stovall, was present at Zhenhua Port Machinery Company (Z. P. M. C.), Changxing Island, Shanghai, China for the purpose of monitoring the fabrication of the SAS/San Francisco/Oakland Bay Bridge.

(Bay 2) Z. P. M. C. Quality Control (QC) personnel are measuring the splice plate to splice plate dimensions, after Heat Straightening on Skin A, of the 89 meter Mockup.

Heat Straightening is being done on Piece 501-1, splice connector plate, which is upside down, has no counter weights on it, and it is supported structurally.

Preheat weld joint --each side--Shear clip--(joint id, piece # covered up by heat blankets.

Tack doubler plate onto plate number 83B, which will become a Skin for the tower mock ups, work is in progress.

(Bay 3) Z. P. M. C. welders Da Lu,--048659, and Wang Zhang Hua,--053753, is welding piece number FJ-3B-4A, electrode Excalibur 9018M, HYR, Welding Procedure Specification (WPS)-B-T-3211-TC-U56, Web connector plate.

Z. P. M. C., Welder--Liu Zihong, # 062447, with Z. P. M. C. QC personnel assisting, and Caltrans QA Inspectors Alfredo Acuna and M. Paul Stovall present, removed corroded wire from the Submerged Arc Welding (SAW), wire feed spool, prior to start of welding plates 70A and 70B, complete joint penetration welds.

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## WELDING INSPECTION REPORT

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Z. P. M. C. Welder, Liu Zihong, 062447, welded plate stiffeners to deck plates, QA Inspector checked that the correct WPS was being used and the welding parameters specified there in were being met by checking and recording-- 268 amps, and 27.8 volts.

### Summary of Conversations:

Caltrans QA Inspector had no conversations with ZPMC QC other than asking the names of welders, WPS #, etc.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Stovall,Paul	Quality Assurance Inspector
<b>Reviewed By:</b>	Cochran,Jim	QA Reviewer

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